

5/03

DART AEROSPACE LTD	Work Order:	22079
Description: Bracket	Part Number:	D3207-1 D3207-2
Dwg: D3207 Rev. A page 1	Qty:	30 40 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC KF 04.06.05	Issue Traveler <u>Note: To be made in multiples of 10</u> Dwg not required	HF	04.12.08	4
2	MV	(1) Flat pattern makes either D3207-1 or D3207-2 Cut blank: 6.5100" x 2.880" (+0.020/-0.000) grain along 2.880" Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3207-1/-2 Batch: M116203	SD EP	04/12/10	40
3	MV	Machine as per Folio FA341 and Dwg D3207 Stack of 10	EP	05/01/20	40
4	QC2	Inspect parts as they come off the CNC machine	SD	05/01/20	40
5	QC8	Second check	ML	05/01/20	40
6	GA	Deburr	Z	05-01-24	40
7	GB	Form 1/2 of stack for D3207-1 as per Dwg D3207 Identify as D3207-1	Z	05-01-24	40
8	GB	Form second 1/2 of stack for D3207-2 as per Dwg D3207 Identify as D3207-2	Z	05-01-24	40
9	QC5	Inspect work to Step 8	MA	05/01/25	41
10	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05/01/25	4
11	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	ML	05/01/26	4
12	QC3	Inspect Powder Coat	CL	05/01/27	44
13	ST	Identify and Stock D3207-1 Qty: 4 D3207-2 Qty: 30 40	CL	05/01/27	44
14	AC	Parts to Stock and Prorate cost to parts per Step 13 Cost / part 7.63 7.62	54C	05-01-28	44
15	DC	Close W/O 7.63 7.62 Inspect Level 21	HF	05.02.02	44

Rev	Date	Change	Revised By	Approved
A	04.04.15	New issue	KJ/RF	<i>John</i>

RELEASED

5/04/2018

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.01.24	7	HUMAN ERROR, made AII 3207-2 parts (Qty 40) Opposite bends turned out to make AII -2 in final bending, instead of -1(x20) -2(x20)	<i>SB</i> <i>Rec'd 01/24</i>	Made D3207-1 to meet QTR required of 4. As per DWG D3207-1 And A 1:1 Dwg. Scale material Batch# M15120	<i>SB</i> 05.01.25	<i>SB</i> 05.01.25	<i>SB</i> per Q52410	<i>SB</i> 05.01.25

Part No: D3207-1/-2PAR #: W/DFault Category: Manuf/Misc PartNCR: YesDQA: LDate: 05/01/24

NOTE: Date & initial all entries

QA: N/C Closed: KJDate: 05/01/24

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022079
Project Name : D3207-2
Project For : WK503
Work Order Type : Main
Main WO Number :
House Part Number : D3207-2
Description : Bracket
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 12-06-04
Est Finish Date : 01-15-05
Act Finish Date :
Drawings Reqd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00	0.00	0.00
=====					
Total Cost :	0.00	0.00	0.00	0.00	0.00
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss)	0.00	0.00

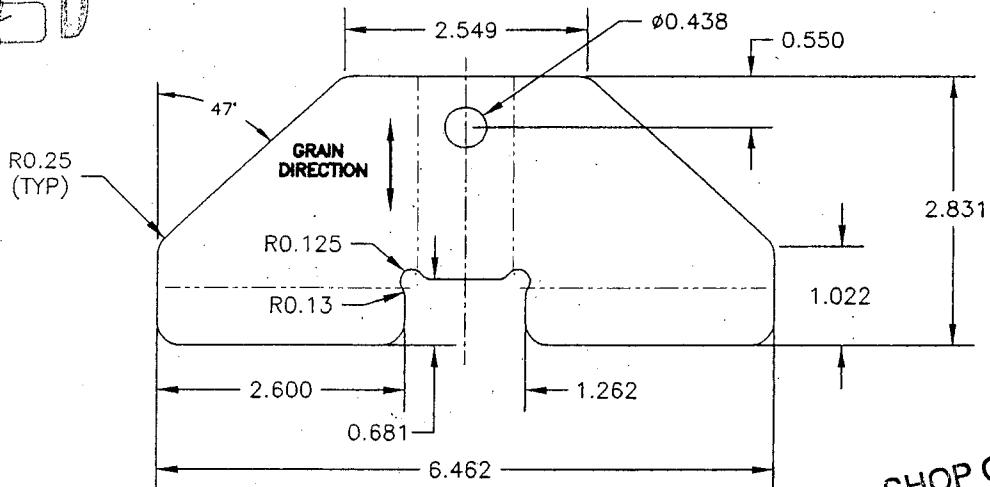
DART

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3207
DATE		REV. A SHEET 1 OF 3 SCALE 1:2
04.01.27		TITLE BRACKET
A	04.01.27	NEW ISSUE

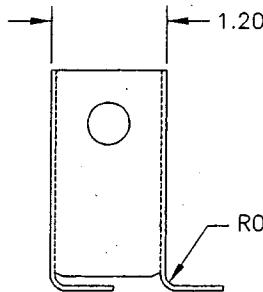
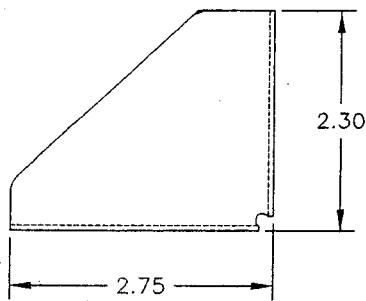
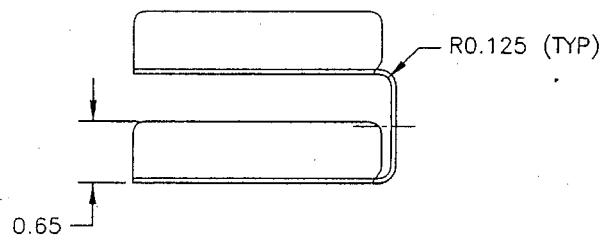
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04.04.05



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WORK ORDER
NO. 22079



D3207-1 BEND DETAIL (SHOWN)
D3207-2 OPPOSITE

D3107-1/-2 BRACKET

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

DART AEROSPACE LTD

Work Order: 22079

Description: BOACKE, T

Part Number: D3207-1

Inspection Dwg: D3207 Rev: A

03207-2

Page 1 of

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:

En

Audited by:

g'm

Prototype Approval:

卷之三

05101122

Date: _____

P-4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	